

# Work Order ID 72741

Thursday, August 11, 2011 9:11:06 AM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 8/11/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/18/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 11-08-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

*Handwritten signature*

~~11-08-11~~  
JG BG 11-9-15

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*Handwritten signature*

SP 11-09-15

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*Handwritten signature*

*Handwritten signature in a circle*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72741

Thursday, August 11, 2011 9:11:07 AM



Page 2

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 8/11/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/18/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: 118

REUA

11/9/11 68 (7)

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/11 94  
ME  
11-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, August 11, 2011 9:11:14 AM

Page 1

Work Order ID: 72741

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 8/11/2011

Required Date: 8/18/2011

Start Qty: 8.00 **7**

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A		Purchased	No			160	Each	494.0000	12	96			
---------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

S+7 Bolt



**Sp 11-09-16**

Location	Loc Qty	Loc Code
----------	---------	----------

ST358	300	
116419	0	
116704	0	
117514	200	
117619	100	
ST359	194	
116704	194	

~~113131~~ **35X**  
**61X**

D2182B		Manufactured	No			160	f	183.2652	2.5	20			
--------	--	--------------	----	--	--	-----	---	----------	-----	----	--	--	--



Rubber Cushion

**Sp 11-09-16**

Location	Loc Qty	Loc Code
----------	---------	----------

ST410	183.26517	
66063	183.26517	

**20**

Cut qty 6 at 5.00" long

D2274		Manufactured	No			160	Each	431.0000	12	96			
-------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	--



Radius Block

**Sp 11-09-15**

Location	Loc Qty	Loc Code
----------	---------	----------

ST010	431	
68942	131	
69736	200	
69773	100	

**96X**

S+7 → measure 8/11/16

S+7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, August 11, 2011 9:11:14 AM

Page 2

Work Order ID: 72741

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 8/11/2011

Required Date: 8/18/2011

Start Qty: 8.00

Required Qty: 8.00

D2432

Manufactured No

160 Each

0.0000

2

1617

206 (24") Bearpaw

D2438

Manufactured No

160 Each

295.0000

6

48

Clamp

## Location

## Loc Qty

## Loc Code

ST456

295

67830

16

68673

81

69737

108

70693

90

Manufactured No

160 Each

565.0000

12

96

## Location

## Loc Qty

## Loc Code

ST016

565

66953

315

71161

250

Purchased No

160 Each

4,845.000

12

96

MS21042L4

Nut

## Location

## Loc Qty

## Loc Code

ST300

4845

117441

700

117601

645

117885

1500

118451

2000

Thursday, August 11, 2011 9:11:15 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, August 11, 2011 9:11:15 AM

Page 3

Work Order ID: 72741

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 8/11/2011

Required Date: 8/18/2011

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

160

Each

4,216.000

24

192



Washer



Sp 11-09-16. *[Signature]*  
 192 X

5  
77

## Location

## Loc Qty

## Loc Code

ST298

4216

116025

16

116805

0

117291

1

117460

2

117591

108

118179

89

118384

4000

*[Handwritten mark]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

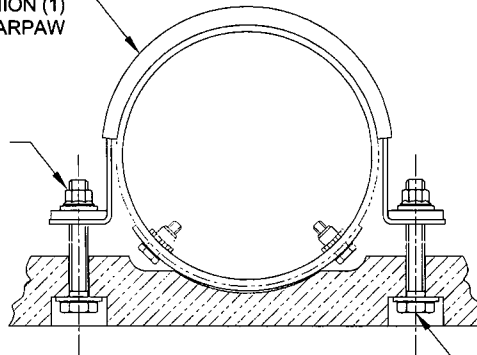
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

D2438 CLAMP (1)  
D2182B050 RUBBER CUSHION (1)  
3 PL PER BEARPAW

MS21042L4 NUT (1)  
AN960JD416 WASHER (1)  
D2274 RADIUS BLOCK (1)  
D2529 WASHER (1)  
AN4-17A BOLT (1)  
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A  
Figure 4 – Clamping Detail

## 5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

• COPYRIGHT © 2002 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: F

Date: 08.08.28